



# Brazing & Soldering **APPLICATION DATA** No. 533 – Air Bag Brackets



## Soldering Machine Specifications

- ❑ **Assembly:** Two-piece steel cylinder/bracket; left and right hand styles.
- ❑ **Paste Filler Metal:** Fusion LHK-1205-650 (Bag 7), 1205°F (651°C) liquidus.
- ❑ **Production Rate:** 450 parts per hour, one operator.
- ❑ **Dimensions:** 64" X 60" welded steel base, 36" dia. aluminum tool plate, stainless water trough, Weiss TC 220 indexer.
- ❑ **Utilities:** Electrical 460/3/60, Control voltage 24VDC, Gas 155 CFH, Water 1 GPM, Compressed Air 28 CFM.
- ❑ **PLC:** Allen Bradley SLC 5/03 with PanelView 550 Interface Panel.
- ❑ **Tooling:** Two sets of fixtures for each part style. Two interchangeable heating manifolds for ease of conversion.
- ❑ **Options:** Two-axis adjustment on paste applicator; device permits incremental movement up to 2 ½" in both (XY) axes; for machine changeover.

## Sequence:

- |            |   |                      |
|------------|---|----------------------|
| Station 1  | - | Load/Unload Assembly |
| Station 2  | - | Open                 |
| Station 3  | - | Paste                |
| Station 4  | - | Heat                 |
| Station 5  | - | Heat                 |
| Station 6  | - | Heat                 |
| Station 7  | - | Heat                 |
| Station 8  | - | Heat                 |
| Station 9  | - | Air Cool             |
| Station 10 | - | Water Cool           |
| Station 11 | - | Water Cool           |
| Station 12 | - | Air Blow Off         |



*Applicator gun dispenses preset deposit of paste filler metal to joint area.*



*Precision heat pattern distributes filler metal evenly throughout joint interface.*



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